

Work Order ID: 81821

81821

Page 1

March-19-12 3:41:14 PM

Item ID: D4310-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Block

Stop

NS2

Start Date: 19/03/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4310

A

90

0.00

90

Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut to 1.50" LONG

SL 12/04/20

100

0.00

100

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FB027 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

SL/PO

12/06/22

40 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81821

March-19-12 3:41:14 PM

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Page 2

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Accept

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Item Name: Block

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

SL/PO

12/06/22

40

Ø

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

out 12/06/25

40

Ø

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: ST 106. 0.00

0.00

130

Packaging

Memo

0.00

Packaging

NOX

SP 12-6-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81821***81821***

Page 3

March-19-12 3:41:14 PM

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Block

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00


140

QC

Memo

0.00

Quality Control

12/6/26 MF
12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-19-12 3:41:18 PM

Page 1

Work Order ID: 81821

81821

Parent Item: D4310-1

D4310-1

Parent Item Name: Block

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 11.01.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MPTFES2.000		Purchased	No			100	f	9.3600	0.1666	7.014737			

MPTFFES2 000

Polytetrafluoroethylene Molded Sheet

**

SL 12/04/19

Location

Loc Qty

Loc Code

MAT

9.36

120727

9.36

7.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

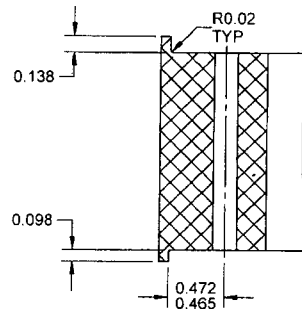
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



04 A

1.689
1.677

0.618
0.610

0.512
0.504

R0.04
TYP

0.551

0.201
0.196 TYP


0.001 A

1.92
REF

WORK ORDER
NO. 81821 MLJ
12/03/19

RELEASED
2010-12-21
PER ECN 10-673

7) WEIGHT: 0.21 lbs

A	NEW ISSUE		10.12.16
REV.	DESCRIPTION		BY DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4310	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BLOCK, ANTI-ROTATION	NTS
DATE	10.12.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

From: David Shepherd <dshepherd@dartaero.com>
Sent: Monday, June 18, 2012 6:56 PM
To: 'Jean-Luc Menard'
Cc: Pat Smith
Subject: D4310-1 Anti Rotation Blocks

JL,

Further to our conversation when I was in Hawkesbury this week and with reference to D4310 Rev A, the 0.004" parallelism on the 1.122 dimension is only important over the length of the 1.122 long tab ($1.673 - 0.551 = 1.122$).

Thanks,
David